



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBE350A94-3700-C-1A
Job Sheet 191743



Part No: RBE350A94-3700-C-1A

Job Qty: 15 pcs

Part Name: Adjustable Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	15 pcs	4/12/19		0.00	5.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	15 pcs	4/12/19		0.00	0.00	QC 5 - 10		DAS MAY 22 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
130	Packaging 3-1 - Stock - B4B	15 pcs	4/12/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S183048



Part: RBE350A94-3700-C-1A

Job No: 191743

Serial No/Batch: S183048

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/19

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLC
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	15 pcs	4/12/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	DAG
					QC 21 - SA - 53	21

MAY 22 2019/13

Part Op 100 - Small Fab-3 (Small Fab) -Assemble as per DWG sheet 2
 Descriptions: 110 - QC5 (QC5- Inspect part completeness to step on W/O)
 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____)
 140 - QC21 (QC21- Final Inspection - Work Order Release)

9-89

Job BOM

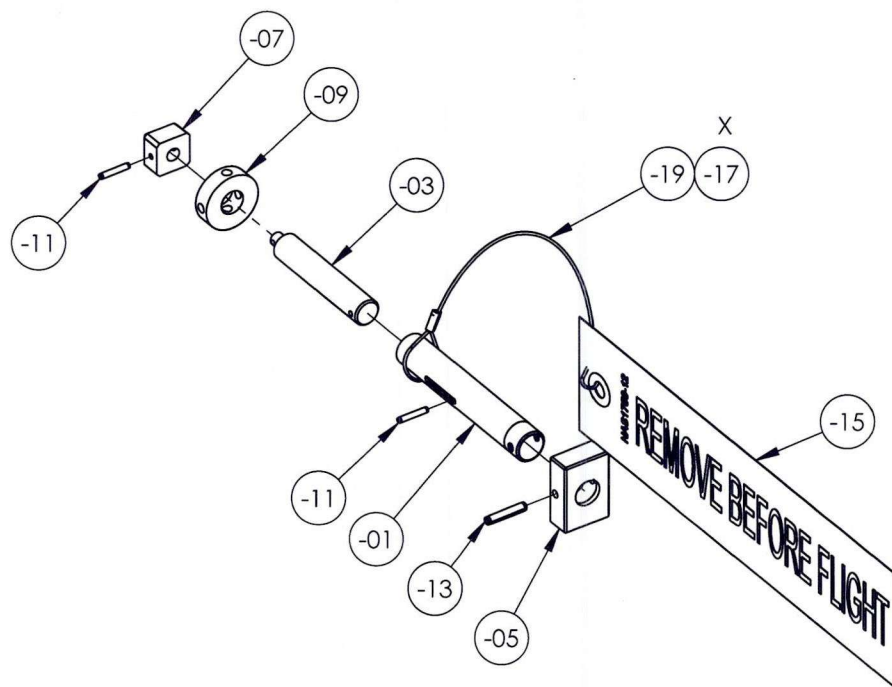
Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	30 Ea (2 ea)	100-Small Fab - 1	515064
92373A181	Roll Pin 1/8 X 3/4	30 Ea (2 ea)	100-Small Fab - 1	515036246
92373A251	Slotted Spring Pin	15 Ea (1 ea)	100-Small Fab - 1	5093346
CL-2-C	Lanyard Wire	12.4950 ft (.833 ea)	100-Small Fab - 1	5119833
NAS1756-12	Remove Before Flight	15 Ea (1 ea)	100-Small Fab - 1	5134216
RBE350A94-3700-C-01	Tube	15 pcs (1 ea)	100-Small Fab - 1	5150643
RBE350A94-3700-C-03	Bolt	15 pcs (1 ea)	100-Small Fab - 1	3415172246
RBE350A94-3700-C-05	Bottom	15 pcs (1 ea)	100-Small Fab - 1	5150643
RBE350A94-3700-C-07	Top	15 pcs (1 ea)	100-Small Fab - 1	5150643
RBE350A94-3700-C-09	Knurled Nut	15 pcs (1 ea)	100-Small Fab - 1	5150643

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	30	558	0
	92373A181	30	133	0
	92373A251	15	63	0
	CL-2-C	12	380	0
	NAS1756-12	15	388	0
	RBE350A94-3700-C-01	15	10	0
	RBE350A94-3700-C-03	15	22	0
	RBE350A94-3700-C-05	15	7	0
	RBE350A94-3700-C-07	15	19	0
	RBE350A94-3700-C-09	15	10	0
Part Specifications				
Specifications could not be found.				

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
6	16-0286	-1A ADDED DRAWING.	2/28/2017	RJC	SM



-1A

ADJUSTABLE BRACE ASSEMBLY



TITLE SWASHPLATE IMMOBILIZING TOOL
ADJUSTABLE BRACE

DWG NO. RBE350A94-3700-C-1 A REV 6

MAT'L	UNLESS OTHERWISE SPECIFIED	
FEAT	DIMENSIONS ARE IN INCHES	
FINISH	.XXX ± .005	FRACTIONS ± 1/8
	.XX ± .01	ANGLES ± .5°
	X ± .1	SURFACES ± 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED:	DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR:	ANDERSON	
QA APPR:	LINDSAY	USED ON MODEL
APPROVED:	MACKOVJAK	EUROCOPTER AS350/355

SCALE 1:4 DATE 8/21/2012 SHEET 2 OF 7

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																												
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																													
Description Work Order Deviation			Disposition																														
						Completed By																											
						Lead hand / Supervisor																											
						QC / QA Coordinator																											
Root Cause		FAULT CATEGORY																															
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		<table style="width:100%;"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																																	